

Work Order ID 108848-2 SP L752

October-29-13 10:09:24 AM

108848

Page 1

Item ID: D3560-042

Accept

N900040100

Setup

Start *NS1*

Revision ID:

Item Name: Arm Weldment

Stop

NS2

Start Date: 10/29/13 Start Qty: 6.00

6

Cust Item ID:

Required Date: 10/29/13 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals: Process Plan: ML5

Date: 13-10-30 Tooling:

Date:

Run

Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3560	Rev D								
130	Pick Kit	0.00							
130	Memo	0.00							
Packaging									
Packaging									

N/A ML5 1404-23

Work Order ID 108848

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Item ID: D3560-042

Accept

N900040100

Setup

Start

NS1

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NS2

Start Date: 10/29/13 Start Qty: 6.00

6

Cust Item ID:

Required Date: 10/29/13 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140		0.00							

140

Large Fab

0.00

(5) 14.04.16 PD

Large Fab

Memo

1-Weld assembly as per dwg D3560

STEP:

- 1- clean material (buff bracket and bottom of arm with blue pad)
- 2- set up bracket and arm on jig
- 3- preheat bracket and arm with torch
- 4- clean before welding with brush
- 5- set up machine to 135 amps
- 6- weld across bottom and top ends
- 7- reheat with torch (65 deg C)
- 8- on one side weld from bottom to top half way
- 9- same for other side (half way)
- 10- from half way point weld the rest of the first side (ease off pedal near end)
- 11- same for remaining side (ease off pedal near end)

150

QC5- Inspect part completeness to step on W/O

0.00

150

Memo

0.00

QC

5

14.4.22

DAS
24
9-89

Work Order ID 108848

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N900040100

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6

Cust Item ID:

Required Date: 10/29/13 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Reject
Stamp

Insp.
Stamp

160

QC9- Inspect visual per QSI004- Fusion Welds

0.00

5

14.420
DAS
24
9-89

160

QC

Quality Control

170

Chemical Conversion Coat per QSI005 4.1

0.00

5

16/14/23

170

HandFinish

Hand Finishing

180

QC3- Inspect Part Finish

0.00

5x

14/04/23
DAS
36
9-89

180

QC

Quality Control

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Accept

N900040100

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Cust Item ID:

Required Date: 10/29/13 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

190

190

Small Fab

0.00

5x

DAS
36
9-89

14/4/23

Small Fab

Memo

0.00

Small Fab

I-Press bushing in D3560 arm per dwg D3562

200

200

QC5- Inspect part completeness to step on W/O

0.00

12/15
27
30

5

QC

Quality Control

210

210

Packaging Identify as per dwg & Stock Location W003 0.00

0.00

Packaging

Memo

0.00

*** STOCK IN STEP CELL***

5x

14-4-23

DAS
28
9-89

Wbrk Order ID 108848

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Item ID: D3560-042

Accept

N900040100

Setup

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Start Date: 10/29/13 Start Qty: 6.00

6

Cust Item ID:

Required Date: 10/29/13 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

220

QC21- Final Inspection - Work Order Release

0.00

220

QC

Quality Control

Memo

0.00

MLJ 14-04-23

MLJ 14-04-23

Picklist Print

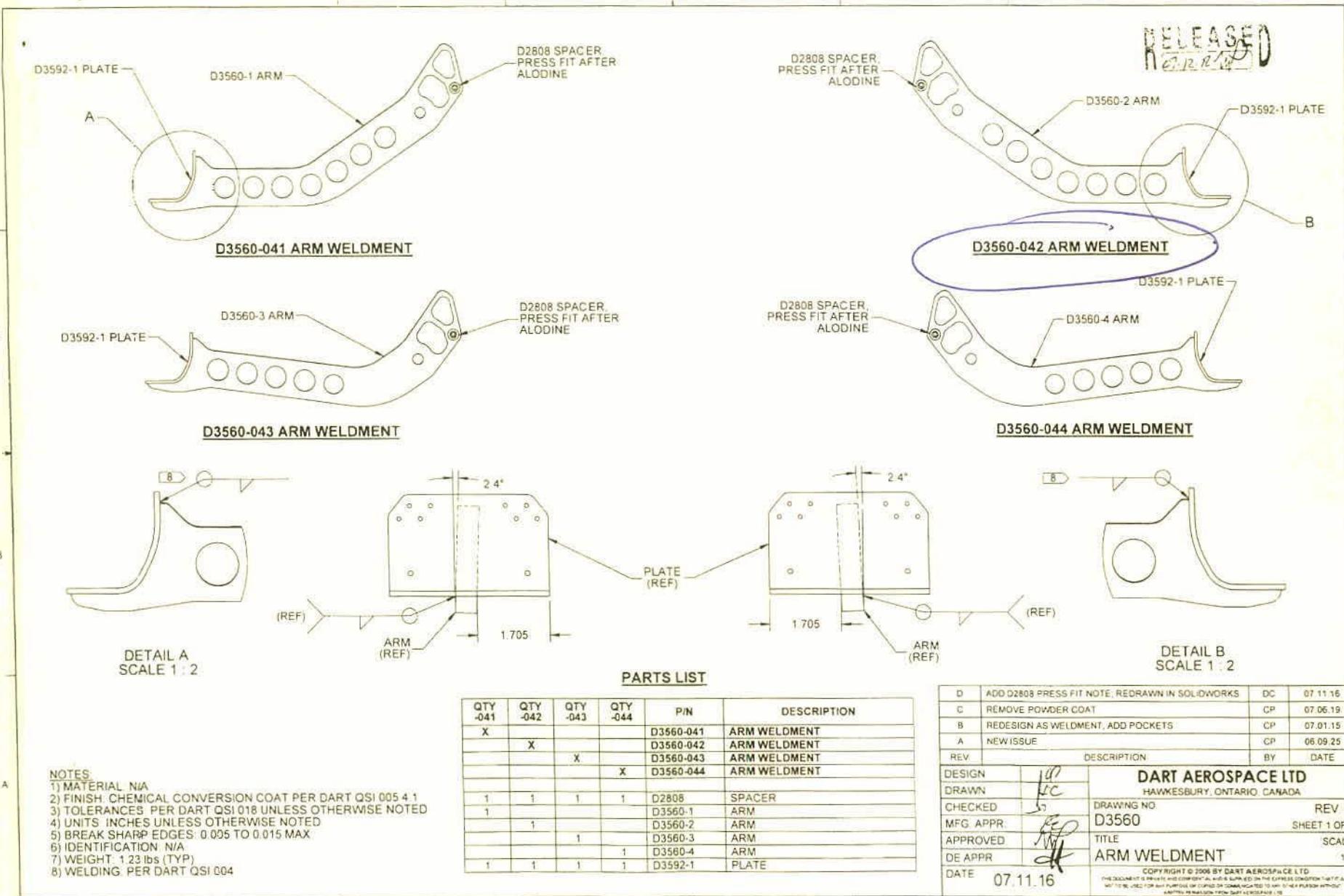
October-29-13 10:09:24 AM

Page 1

Work Order ID: 108848
 Parent Item: D3560-042
 Parent Item Name: Arm Weldment
 Start Date: 10/29/13 Required Date: 10/29/13
 Start Qty: 6.00 Required Qty: 6.00

Comments: IPP Rev:A New Issue 07.05.24 EC
 IPP rev B ECN 987 07.10.09 EC verified by: DD
 IPP Rev:C ECN1048 07-12-18 DD verified by: EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2808 Spacer		Manufactured	No				Each	44.0000		6		14/04/23	DAS 36 9-89
				<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>				
				GA			44					5	
				103647			22						
				105456			17						
				85479			5						
D3560-2 Arm		Manufactured	No				Each	6.0000		6		(5) 14-04-16	PD
				<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>				
				WA003			6					B107828->5	
				107521			6						
D3592-1 Plate		Manufactured	No				Each	43.0000		6		(5) 14-04-16	PD
				<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>				
				WA002			2					B107122->5	
				47015			2						
				WA003			41						
				103585			3						
				106184			23						
				82022			8						
				97778			7						



108848 MLC
 13-10-30

8

7

6

5

4

3

2

108848

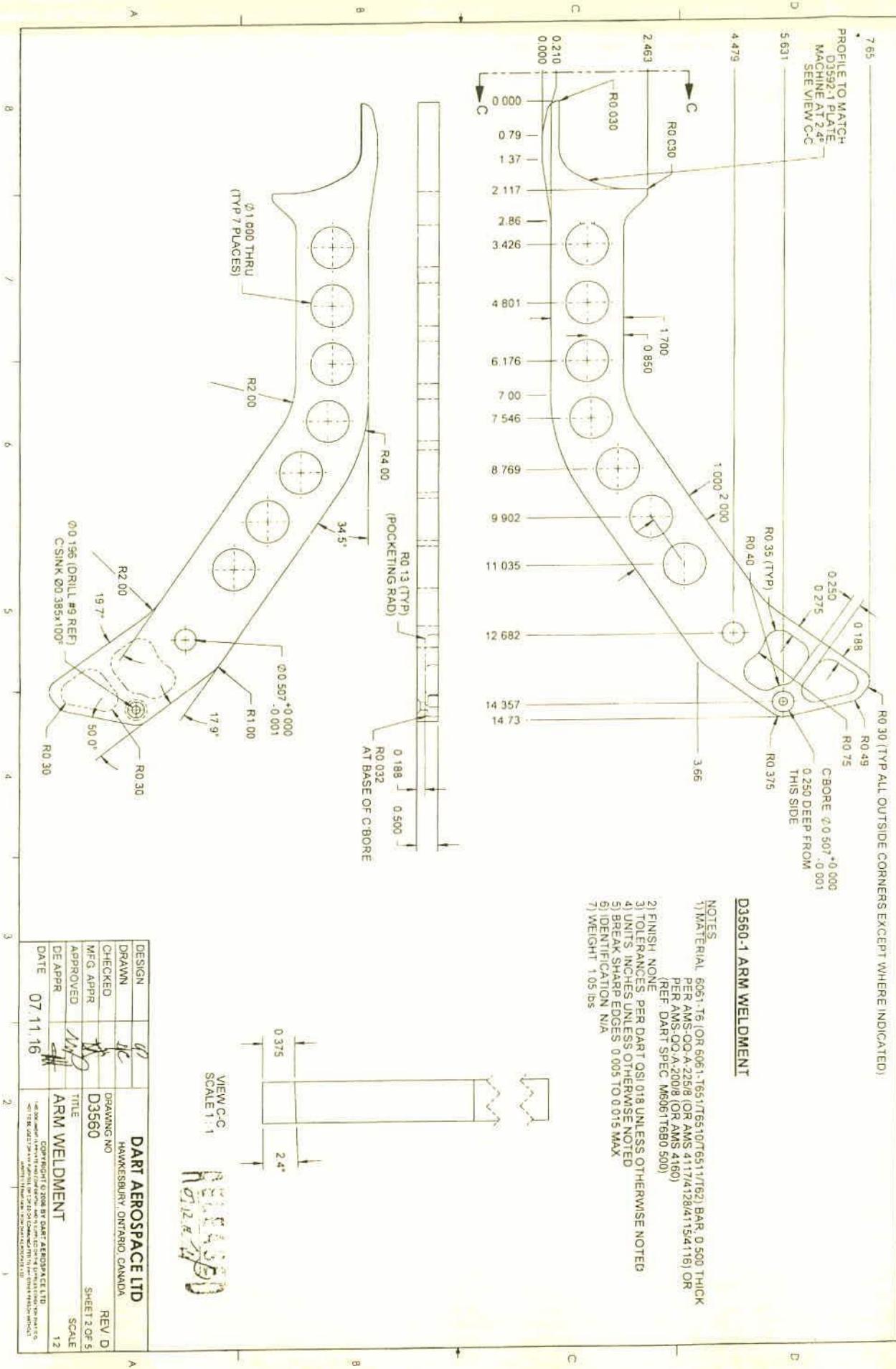
7.65
* PROFILE TO MATCH
D3560-1 PLATE
MACHINE AT 2.4°
SEE VIEW C-C

5.631
4.479
2.463
0.000
0.210
0.79
1.37
2.117
2.86
3.426
4.801
6.176
7.00
7.546
8.769
9.902
11.035
12.682
14.357
14.73
R0 30 (TYP)
R0 40
R0 40
R0 35 (TYP)
R0 40
R0 40
R0 375
R0 375
R0 49
R0 75
CBORE Ø 0.507 ± 0.000
0.250 DEEP FROM
THIS SIDE

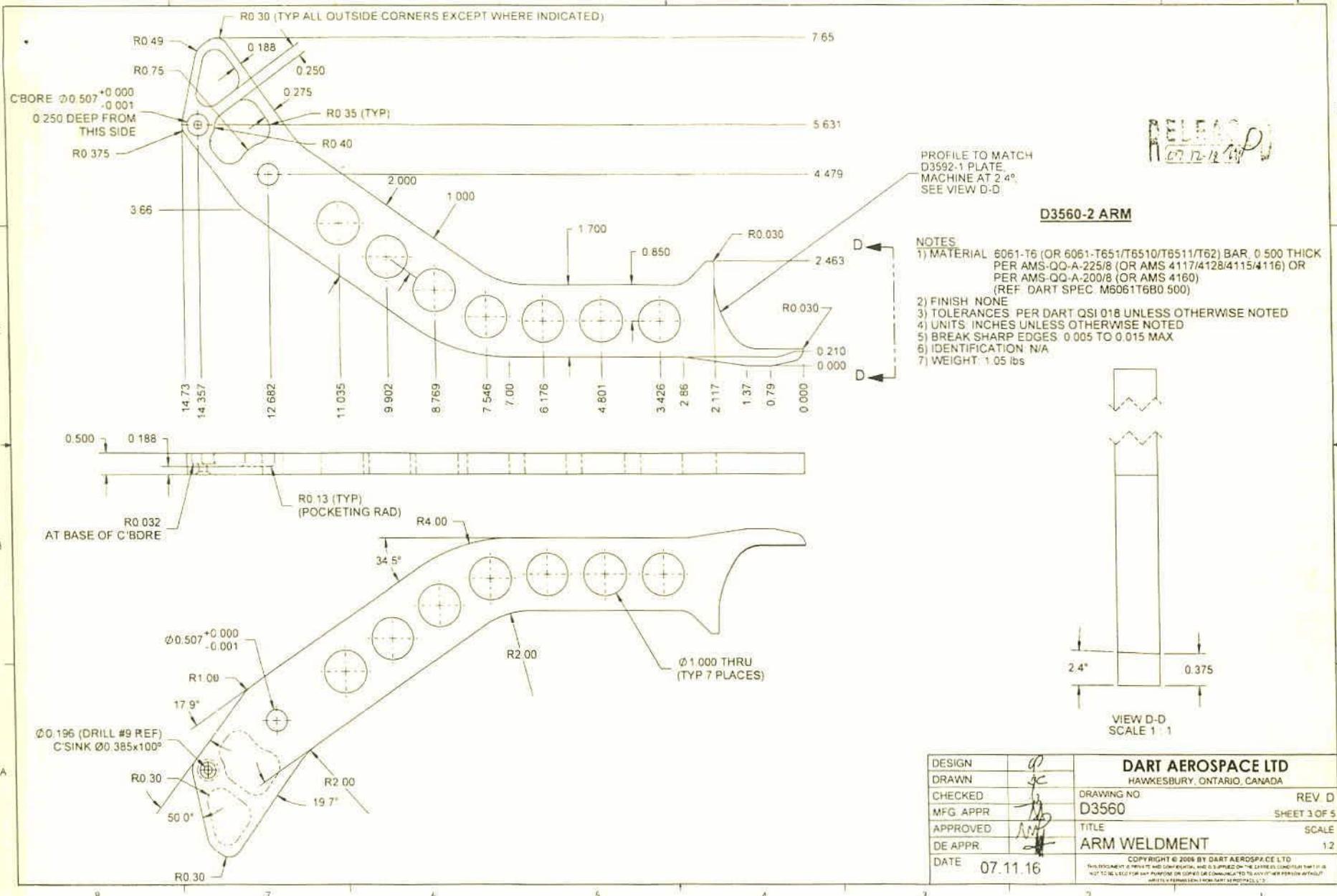
D3560-1 ARM WELDMENT

NOTES
1) MATERIAL 6061-T6 (OR 6061-T651/T6510/T62) BAR 0.500 THICK
PER AMS-QQ-A-2008 (OR AMS 4117A/128/4154116) OR
PER AMS-QQ-A-2008 (OR AMS 4160)
(REF DART SPEC MS0611T660 500)

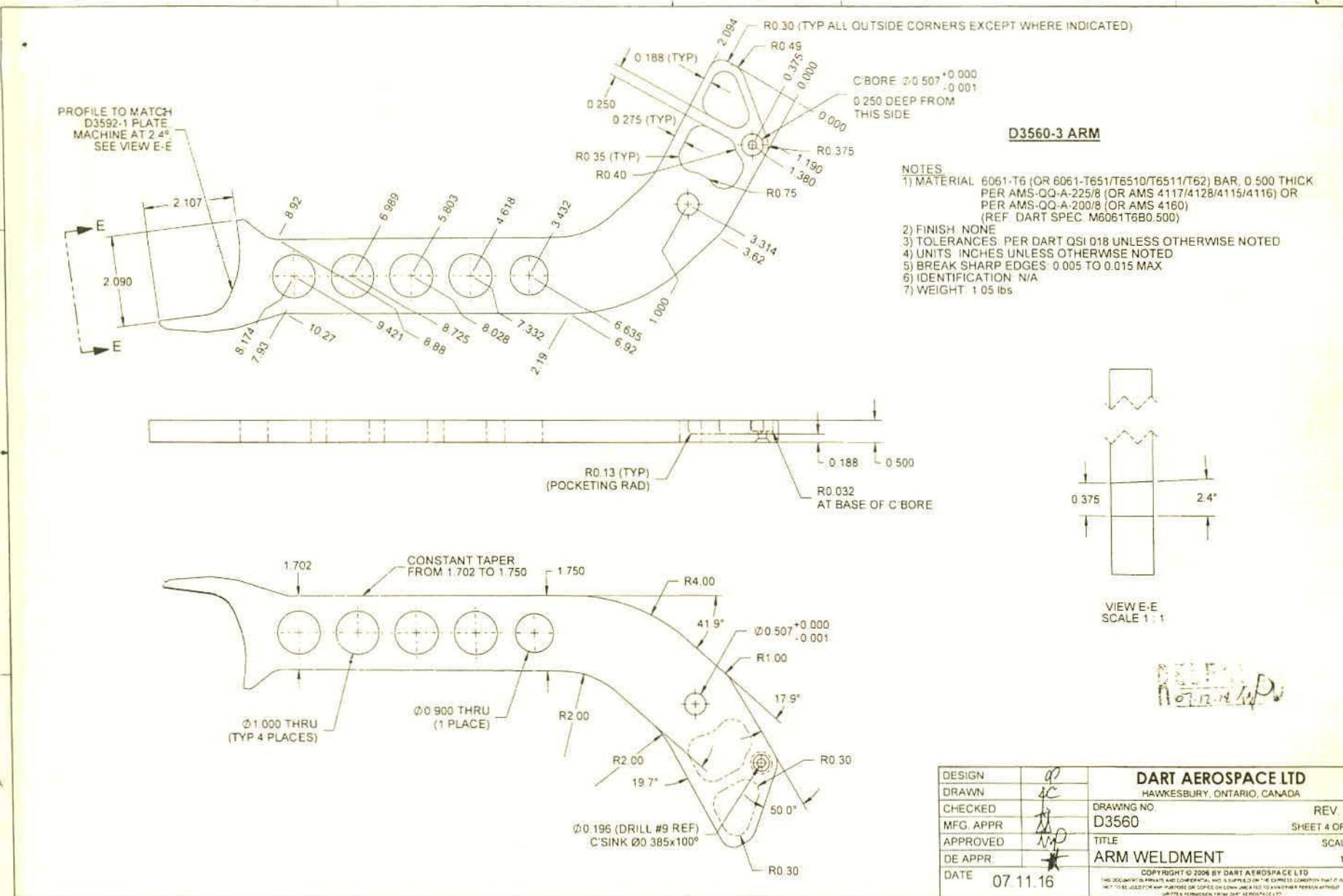
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART OS1 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.05 lbs



108848

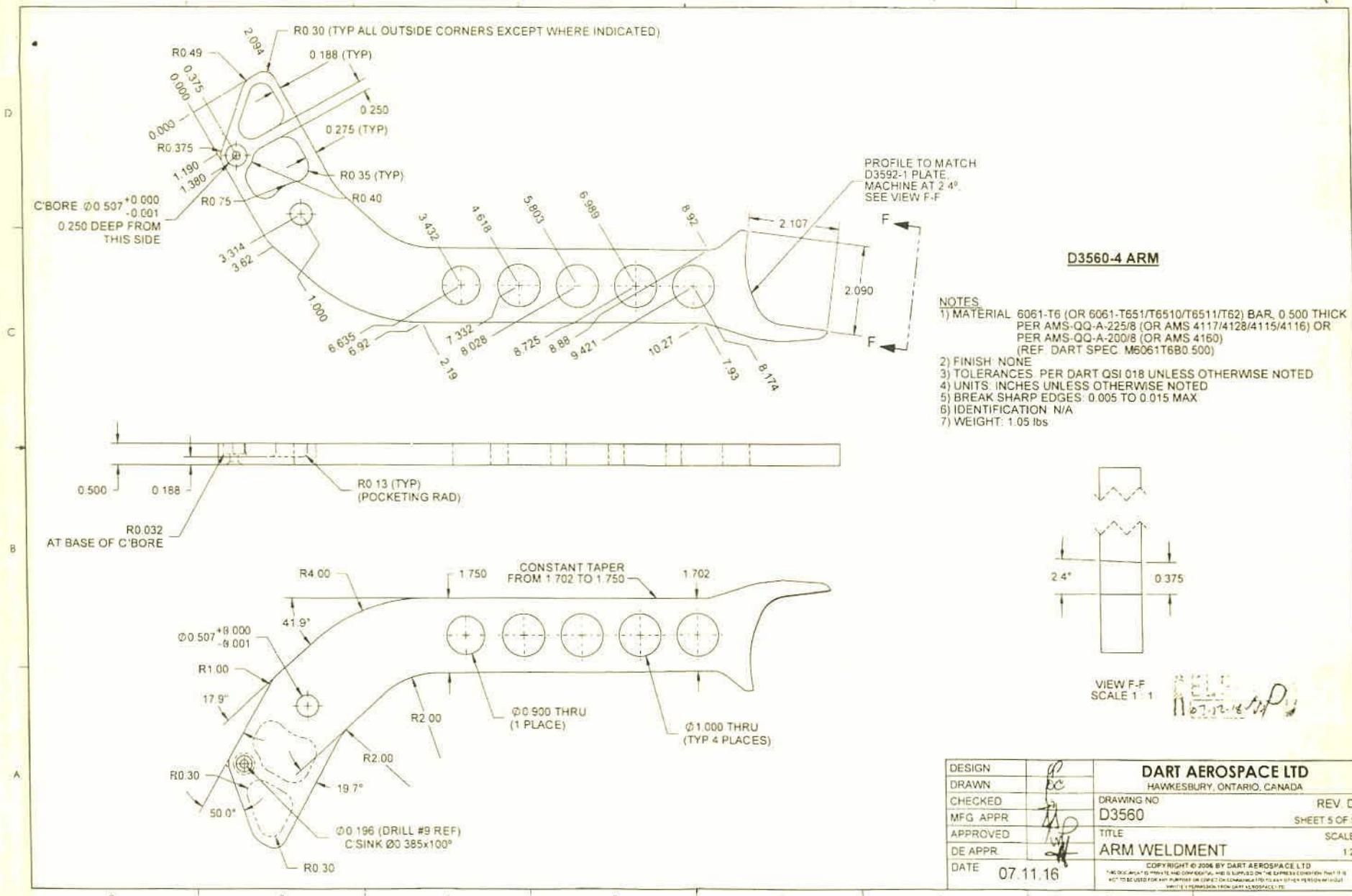


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MFG APPR	<i>1</i>	D3560	SHEET 3 OF 5	
APPROVED	<i>MP</i>	TITLE	SCALE	
DE APPR.	<i>MP</i>	ARM WELDMENT	1:2	
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DRAWN	4C	HAWKESBURY, ONTARIO, CANADA
CHECKED		REV. D
MFG. APPR		DRAWING NO.
APPROVED		D3560
DE APPR		SHEET 4 OF 5
DATE	07.11.16	TITLE
		SCALE
		ARM WELDMENT

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DRAWN	<i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>[Signature]</i>	DRAWING NO
MFG APPR	<i>[Signature]</i>	D3560
APPROVED	<i>[Signature]</i>	REV. D
DE APPR	<i>[Signature]</i>	SHEET 5 OF 5
DATE	07.11.16	SCALE
		1:2

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DART AEROSPACE LTD DT 10042	Work Order: 108848-2
Description: Jig for weld- <u>g</u> D3560-042(044) arm	Part Number: D3560-042
Inspection Dwg: 3560 Rev: D	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

100

102

Measured by:	9-89	Audited by:	989	Preliminary Approval:	
Date:	14.04.17	Date:	14.04.17	Date:	

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	

10.04.15